

Work Order ID 109263-1

November-15-13 3:03:14 PM

split ASAP

109263

Page 1

Item ID: D4545-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, RH Inner Lower)

Start Date: 11/15/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4545

C

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

13X

13/11/25

DAS
36
9-89

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- ASSEMBLE AND BEND TABS AS PER DWG

2- DISASSEMBLE AND DEBURR

3- DIMPLE HOLES AS PER DWG

DAS
30
9-89

13X

13/11/25

DAS
36
9-89

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Item ID: D4545-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer. RH Inner Lower)

Start Date: 11/15/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

Hand Finish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

13

13

13-11-26

2x

13/11/26

DAS
36
9-89

THE UNIVERSITY OF CHICAGO LIBRARY
1000 S. EAST ASIAN LIBRARY
CHICAGO, ILL. 60607-7073
TEL: 773/936-5000 FAX: 773/936-5001
WWW.CHICAGO.EDU

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Item ID: D4545-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Retainer, RH Inner Lower)
 Start Date: 11/15/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/18/13 Req'd Qty: 4.00 *4* Customer:

Reference: Run Start *NR1*
 Approvals: Process Plan: Date: Tooling: Date: Stop *NR2*
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145		0.00				2x			13/11/26
145		0.00							
Small Fab	Memo								
Small Fab	INSTALL NUT PLATES AND ASSEMBLE AS PER DWG								
147	QC5- Inspect part completeness to step on W/O	0.00				2			
147		0.00							
QC	Memo								
Quality Control	count tabs and record quantity QTY: _____								
190	Identify as per dwg & Stock Location 81531	0.00				2x			13-11-26
190		0.00							
Packaging	Memo								
Packaging									

DAS
26
9-89

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Item ID: D4545-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, RH Inner Lower)

Start Date: 11/15/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

[Signature] / RM 13/11/27

RB-11-27

Picklist Print

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Work Order ID: 109263
Parent Item: D4545-042
Parent Item Name: Retainer, RH Inner Lower)

Start Date: 11/15/13

Required Date: 11/18/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM IPP REV:B 12.02.27 AS PER
DWG REV.B DD VERF:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-2 Bracket		Manufactured	No			100	Each	6.0000	1	4		13/11/26	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		6	B109639						
				103176		1							
				108239		3							
				81261		1							
				91416		1							
D4542-2 Retainer, Inner, RH		Manufactured	No			100	Each	21.0000	1	4		13/11/26	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		21							
				101316		15							
				103184		5							
				90449		1							
MS20426AD3-4 RIVET		Purchased	No			145	Each	10,527.000	38	152		13/11/26	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST334		5042							
				123164		35							
				m127432		5007							
				ST505		24							
				104374		12							
				123021		12							
				ST509		5461							
				124586		120							
				125578		5341							

B108236 (3X)
M125578 (76)
M124814
E 494

Picklist Print

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Work Order ID: 109263

Parent Item: D4545-042

Parent Item Name: Retainer, RH Inner Lower)

Start Date: 11/15/13

Required Date: 11/18/13

Start Qty: 4.00

Required Qty: 4.00

MS21059L3K

Purchased

No

145

Each

679.0000

18

72

Nutplate

Location

Loc Qty

Loc Code

ST316

343

m127430

343

st507

336

124586

336

38

MS21061L3K

Purchased

No

145

Each

97.0000

1

4

NUT PLATE

Location

Loc Qty

Loc Code

ST316

35

125268

35

ST317

62

123355

1

123603

60

124093

1

132

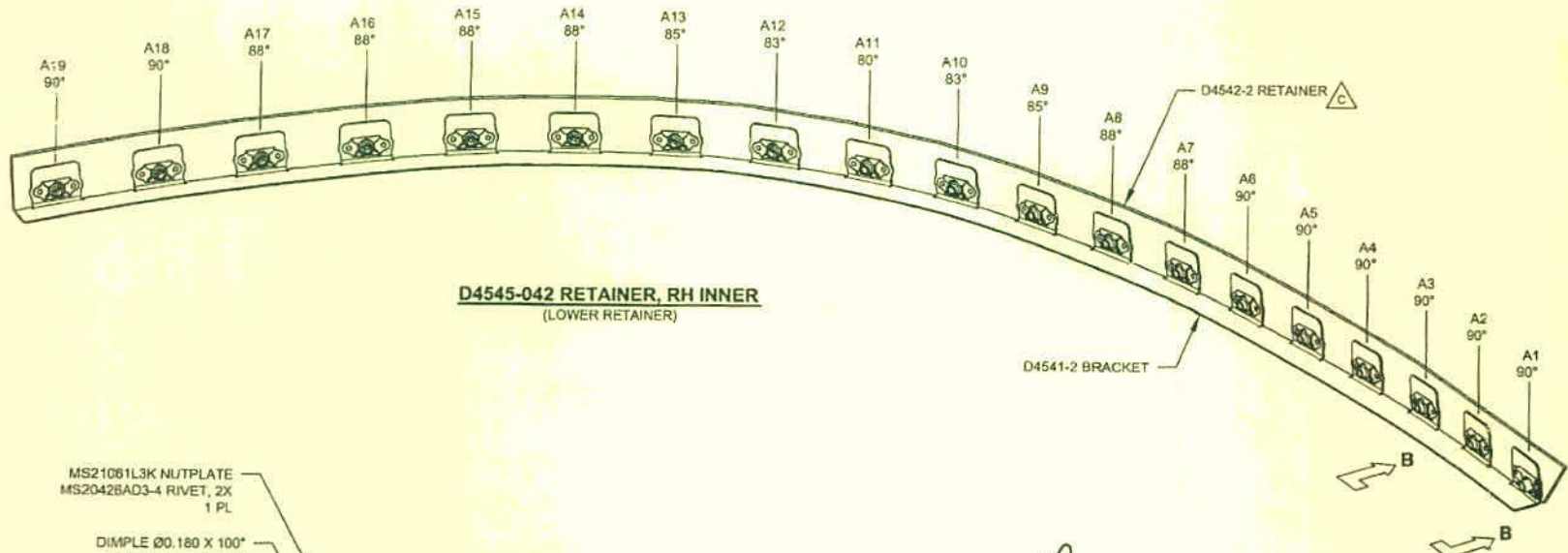
DAS
36
9-89

DAS
36
9-89

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Shop Packet Print

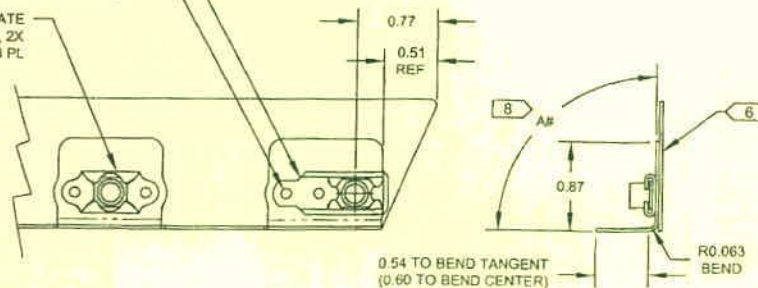
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MS21081L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
1 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 38 PL
(ALL NUTPLATES)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
18 PL



VIEW B-B
NOT TO SCALE

109263

UNDER REVIEW
13/1/13
CK 13/1/13

2012-05-07

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ADP	D4545	SHEET 3 OF 9
APPROVED	ADP	TITLE	SCALE
DE APPR.	ADP	RETAINER, INNER	NTS
DATE	12.04.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD	

